

Work Order ID 133371 2

Monday, June 08, 2015 11:16:04 AM

133371

Page 1

Item ID: D4061-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Ski Cushion

Start Date: 6/8/2015 Start Qty: 80.00 *80*

Required Date: 6/26/2015 Req'd Qty: 80.00 *80*

Cust Item ID:

Reference:

Customer:

Approvals: Process Plan: MF Date: 15-6-8

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4061	C								

100

0.00

100

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

1-Mill as per folio FB292

FOLIO REV: AA

DWG REV: C

2-Deburr as required

8 0 only
1506/12

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

8 0 only
2/5-6/11
only 1506/12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 133371

133371

Page 2

Monday, June 08, 2015 11:16:04 AM

Item ID: D4061-1 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Ski Cushion

Start Date: 6/8/2015 Start Qty: 80.00 *80* Cust Item ID:

Required Date: 6/26/2015 Req'd Qty: 80.00 *80* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00				B	J	DAS 37 9-89	15.06.14
Quality Control									
130	Identify as per dwg & Stock Location: <u>st 544</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

B

DAS
27
9-89

JUN 15 2015

ML5

JUN 22 2015

ML5

JUN 15 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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11-01-11 56 56								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
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OTHER : ☐																									

Picklist Print

Monday, June 08, 2015 11:16:03 AM

Page 1

Work Order ID: 133371

133371

Parent Item: D4061-1

D4061-1

Parent Item Name: Ski Cushion

Start Date: 6/8/2015

Required Date: 6/26/2015

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP REV:A NEW ISSUE JLM 10-02-18 VERIFIED BY:EC IPP
REV:B 11.01.10 AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4287-3		Manufactured	No			100	F	27.2870	0.4125	35			
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D4287-3

Uhmw U-Channel

DAS

37

9-89

15.06.09

Location

Loc Qty

Loc Code

ST479

27.287

132385

27.287

27.287 SC.

DQA: _____ Date: _____

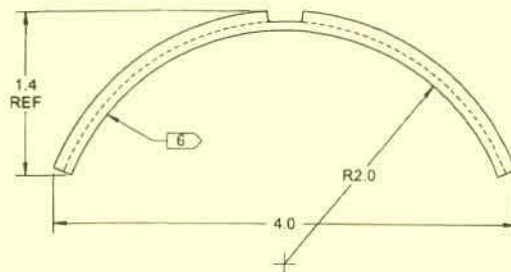


WORK ORDER NON-CONFORMANCE / UPDATE

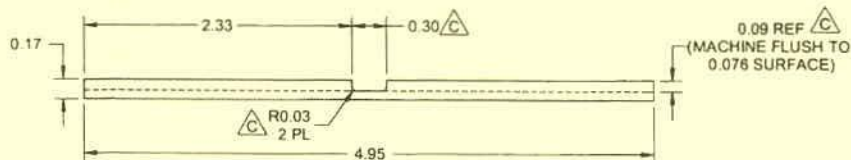
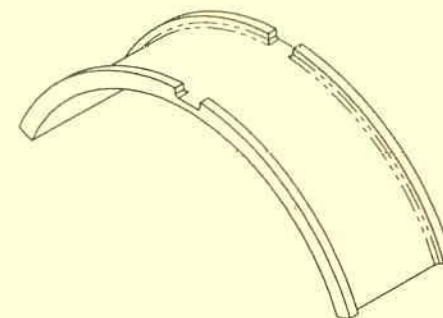
QA Closed: _____ Date: _____

Work Order update only ☐

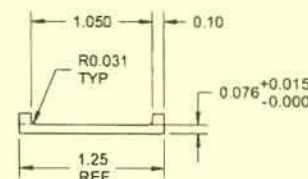
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Root Cause		FAULT CATEGORY			
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OTHER : _____					



D4061-1 412 SKI CUSHION
(MAKE FROM D4061-1F)



D4061-1F FLAT MACHINED STATE



RELEASED
2015-06-03
EN 15-574

- NOTES:
1) MATERIAL: MAKE FROM D4287-3
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4061-1" AND B/N "BXXXXX" PER QSI 044 6.1
7) WEIGHT: 0.02 lbs

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO. D4061	REV. C SHEET 1 OF 1
MFG. APPR.	DD	TITLE 412 SKI CUSHION	SCALE NTS
APPROVED	HS	DATE 15.05.14	
DE APPR.	DS		
REV.	DESCRIPTION	BY	DATE
C	ADD 0.30 NOTCH, 2 PL. REF DIMS FOR D4060-1. REASON: PAR 14-368, 14-331, NCR 14-3521	VS	15.05.14
B	CHANGED RAW MATERIAL TO REDUCE MANUFACTURING COSTS. PART NOW MACHINED FLAT AND SHAPED WITH ADEQUATE RADIUS. REF. PAR10-29.	MB	10.12.07
A	NEW ISSUE	MB	10.03.31

APPROVED

DQA: _____ Date: _____

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